

Date: Thursday, 3/13/2008 10:19:23 AM  
User: Kim Johnston

# Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HI-STEP LEG ASSEMBLY
Job Number :	37925		
Estimate Number :	10355		
P.O. Number :		Part Number :	D2582
This Issue :	3/13/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2582 REV B
First Issue :	1 /	Project Number :	N/A
Previous Run :	37452	Drawing Revision :	B
		Material :	
Written By :		Due Date :	3/28/2008
Checked & Approved By :	<u>H 08 03 13</u>	Qty:	14
Comment :	Est Rev:F Removed Manufacturing 05-11-07 JLM	Um:	Each
	Est Rev:G Added part # to Sub 06-08-10 JLM		
	Est Rev H New pick list 08.01.11 EC		
	verified by: DD		

## Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	37925A	STEP LEG
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Comment: Sub-Component STEP LEG  
D2278 B 37925A (1)

B 37452A (7)

2.0	37925B	STEP SPACER
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Comment: Sub-Component STEP SPACER  
D2322 B B 36710B (7)

B 37452B (2)

B 37925A (5)

3.0	37925C	STEP SPACER
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Comment: Sub-Component STEP SPACER  
D2279 B B 22585 (1)

B 31407D (3)

4.0	37925D	STEP SPACER
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Comment: Sub-Component STEP SPACER  
D3720-1

B 37925D x11 ✓

B 37452D x2 ✓

B 36710 D x1 ✓

ml 08/04/02

5.0	37925E	STEP SPACER
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Comment: Sub-Component STEP SPACER  
D3720-2

B 37925E x9 ✓

B 36710E x2 ✓

B 37452E x3

ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 37925

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : ~~220.0000~~ Each(s) 308

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4 Rivet

M106552 ?

ml

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~40.0000~~ Each(s) 56

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5 Rivet

M104156

✓ ml

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

ml 08/04/02 x14

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/03 (x14)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

08 04 07

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



mf

08-04-08

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2278 STEP LEG  
(2 PLACES)

MS20470AD4-4 RIVET  
(5 PLACES PER SIDE)  
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2279 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET  
(6 PLACES PER SIDE)  
(INSTALL FROM OUTSIDE OF ASSEMBLY)

### D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET  
(2 PLACES)

MS20470AD4-5 RIVET  
(2 PLACES)

B  
D3720-2 STEP SPACER

B  
D3720-1 STEP SPACER

C'SINK ON INSIDE  
GRIND RIVET FLUSH TO  
SURFACE AS REQUIRED  
(BOTH SIDES)

RELEASED  
06-01-10

### D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

#### NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs.

B	REPLACE D2280 SPACERS WITH D3720-1/2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED	LG		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.27		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B  
D2582 SHEET 1 OF 1

TITLE SCALE  
STEP LEG ASSEMBLY NTS

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